












Date: Monday, 22/09/2008 1:05:38 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-BOLT SPACER
Job Number : 42185	
Estimate Number : 12321	
P.O. Number :	Part Number : D34901
This Issue : 22/09/2008 S.O. No. :	Drawing Number : D3490 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39600	Material :
Written By :	Due Date : 29/09/2008 Qty: 50 Um: Each
Checked & Approved By : <u>JLD 08.9.22</u>	
Comment : Est Rev:A New Issue 06-03-03 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M6061T6T0500W049 6061-T6 RD Tube .500 x.049W
	 (50)
Comment: Qty.: 0.2793 f(s)/Unit Total : 13.9650 f(s) 6061-T6 Tube .500 x.049W (M6061T6T0.500W.049) Batch: <u>m108250</u> <u>mmt 08/09/29</u>	
2.0	HARDINGE HARDINGE CNC LATHE SMALL
	 (50)
Comment: HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA628 & DWG D3490 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED <u>mmt 08/09/29</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 (50)
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>JLD 08.09.22</u>	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	 (50)
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>DARTHEG</u> <u>8/9/30</u> <u>SC</u>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

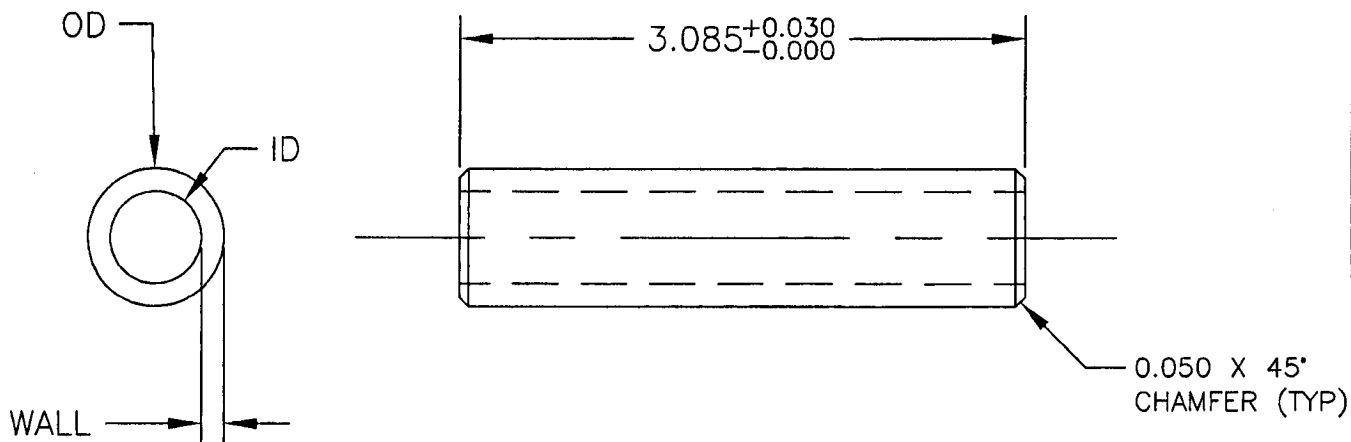
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURNED
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42185

RELEASED
06.02.07

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